

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011983**Date Inspected:** 11-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans Office of Structural Material (OSM) Quality Assurance (QA) Inspector, D. Sukanthan was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

**OBG # BAY 1**

This QA observed ZPMC qualified welding personnel identified as 219188 perform Flux Cored Arc Weld (FCAW) Process on weld joint 20TR1-017-003. ZPMC Quality Control Personnel (QC) identified as Mr. Yin Dong Hai was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-TC-U5-F.

**OBG # SEGMENT 7BW + SEGMENT 7CW**

This QA observed ZPMC qualified welding personnel identified as 066673 perform Flux Cored Arc Weld (FCAW) Process on weld joint SP430-001-031,032. ZPMC Quality Control Personnel (QC) identified as Mr. Li Yang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-B-U2-F.

This QA observed ZPMC qualified welding personnel identified as 066746 perform Flux Cored Arc Weld (FCAW) Process on weld joint SP439-001-056,057. ZPMC Quality Control Personnel (QC) identified as Mr. Li

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## WELDING INSPECTION REPORT

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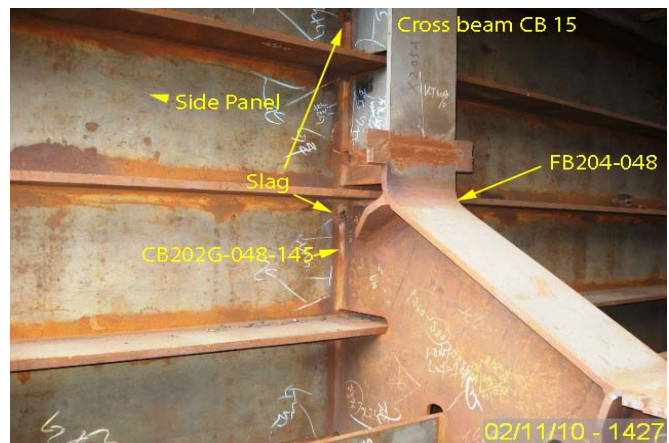
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Yang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-B-U2-F.

### OBG # CROSS BEAM CB 15

During random in process inspection of this crossbeam this QA observed various fillet welds have slag and poor weld profile. Fabrication of this crossbeam is still in process and has not yet been released to QA for final inspection. No other significant work was being performed on this crossbeam during the time QA was present. See attached picture for more information.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

As mention above

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-00422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Sukanthan,Dhanasingh	Quality Assurance Inspector
<b>Reviewed By:</b>	Hall,Steven	QA Reviewer

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